

Date: Monday, 22/06/2009 10:15:01 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HAT BIN, 407, GREY
Job Number : 48642A	
Estimate Number : 13977	
P.O. Number :	Part Number : D38351KGY
This Issue : 22/06/2009 S.O. No. :	Drawing Number : D3835-1
Prsht Rev. : NC	Project Number :
First Issue : / / Type : THERMOFORMING	Drawing Revision : <i>mc blc</i>
Previous Run :	Material : MKYD6185S125P352068
Written By :	Due Date : 24/06/2009 Qty: 2 Um: Each
Checked & Approved By : <i>mf 09-06-22</i>	
Comment : Est. Rev. A New Issue 09/06/02 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S125P352068	6185 Kydex 125" steel grey
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Comment: Qty.: 11.4264 sf(s)/Unit Total : 22.8528 sf(s)
 6185 Kydex .125" Grey *M 11/807*

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Machine set up

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

4.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3835-1 and folio (FTA 407 Hatbin)

Dwg. Rev. *C*
 Folio Rev. *B*

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN, 407, GREY

Job Number: 48642A

Part Number: D38351KGY

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

OK 09/06/18

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

OK 09/06/19

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

OK 09/06/19

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/24 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

INTHERMOFORMING
WAITING PACKAGING

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24

Job Completion



09-06-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3835-1 KGY PAR #: N/A Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Ad Date: 10-01-21

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>48642A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/06/21	7.0	DRAWN PORTION OF AA Bin IS THIN + SOFT	<u>RE</u> Q25 042 09.06.21	REINFORCE AFFECTED SECTION PER ATTACHED INSTRUCTION BASED ON TR-D407-781 REPAIR	<u>BB</u> 09/06/21	<u>S</u> 09/06/21	<u>RE</u> Q25 042 09.06.21	<u>S</u> 02/06/21

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 48648A
Description:	Part Number: D3835-1K
Inspection Dwg: D3835 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: WH

Date: 09/06/18

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>0.65"</u>	<u>+/- 0.05</u>	<u>0.654</u>	✓			
<u>0.80"</u>	<u>+/- 0.05</u>	<u>0.827</u>	✓			
<u>1.00"</u>	<u>+/- 0.05</u>	<u>1.02</u>	✓			
<u>1.20"</u>	<u>+/- 0.05</u>	<u>1.208</u>	✓			
<u>0.050"</u>	<u>MIN</u>	<u>0.104</u>	✓			
<u>0.030"</u>	<u>MIN.</u>					See Attached

Measured by: WH

Date: 09/06/24

Audited by: BB

Date: 09/06/24

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

[Handwritten Signature]

8 7 6 5 4 3 2 1

MIN FLANGE
THICKNESS
0.050

14.8
REF

11.3
REF

0.65^{+0.05}_{-0.00}

48.0
REF

36.25
REF

A

12.5
REF

B2-1

54.1
REF

1.00^{+0.05}_{-0.00}
TYP

1.20^{+0.05}_{-0.00}
TYP

6

SECTION A-A B7-1
SCALE 2X

0.80^{+0.05}_{-0.00}
TYP

MIN THICKNESS IN
DRAWN PORTION IS
0.030

RELEASED
9/15/2005

D3835-1 HAT BIN
(BELL 407)

48642A

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9449 PER DART QSI 022. TRIM PER MOLD

C

C

PART NUMBER	DESCRIPTION
D3835-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.125-P3-62015)
D3835-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.125-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3835-1KIV AND ADD STEEL GRAY P/N D3835-1KGY (ZN A5-1)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1) REASON: TO IMPROVE DURABILITY	PH	09.02.19
A	NEW ISSUE	PH	08.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>		
MFG. APPR.	<i>PH</i>		
APPROVED	<i>PH</i>		
DE APPR.	<i>PH</i>		
DATE	09.05.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3835		REV. C SHEET 1 OF 1	
TITLE HAT BIN (BELL 407)		SCALE NTS	
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With reference to Test Report, TR-D407-781-1 Rev. A, the following may be performed to reinforce the drawn portion of the D3824-1/-3, D3835-1, D3845-1, D3850-1 Hat Bins.

Kydex 6185 reinforced with 9 oz cloth using Hysol 9330 A/B and ATH208
Procedure:

- 1) Abrade smooth side of Kydex 6185 with scotchbrite and clean with acetone
- 2) Mix Hysol 9330 – Part A to Part B – 100% to 33% by weight in accordance with manufacturer's instructions

Hysol 9330 (2 part system)

BATCH # M 112099

- 3) Mix item 2) with ATH208 (Aluminum TriHydrate) at 50% by weight

ATH208

BATCH # M 110065

Ex:

100 grams of Hysol 9330 Part A + 33 grams of Hysol 9330 Part B = 133 grams of Hysol 9330

Therefore, use 133 grams of ATH208

- 4) Saturate 1 layer of 7781 9oz glass Cloth (item # FG778150550ROL) with mixture of Hysol 9330 and ATH208

9oz glass Cloth

BATCH # M 111166

- 5) Apply item 4) to reinforce drawn portion of the D3824-1/-3, D3835-1, D3845-1, D3850-1 Hat Bins.
- 6) QC 5

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43642A